

Date: * Monday, 4/23/2007 3:42:12 PM
 User: * Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 32027		
Estimate Number	: 11376		
P.O. Number	: N/A	Part Number	: D33872
This Issue	: 4/23/2007 S.O. No. : N/A	Drawing Number	: D3387-UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: UNDER REVIEW A
Previous Run	: 27289	Material	: N/A
Written By	: <u>07.04.23</u>	Due Date	: 5/1/2007 Qty: 2 Um: Each
Checked & Approved By	: <u>07.04.23</u>		
Comment	: Est:A 05.06.10 New Issue KJ/JLM Est:B 06.03.22 Split c'sink op. EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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Comment: Qty.: 1.5680 f(s)/Unit Total : 3.1359 f(s)

6061-T6 Bar .50" x 6.0"

Material: 6061-T6/T651 (QQ-A-200/8)

(M6061T6B0.500x06.000)

Identify for D3387-2 3102508

Batch: M101919

J.L 07/04/24

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blank: 6.000" x 0.500" x 17.800" long

J.L 07/04/24

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA512 and Dwg D3387

Identify as D3387-2

Tumble and Deburr NO sharp edges

J.L 07/04/24

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

C'sink Ø0.375" as per Dwg D3387

J.L 07/04/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: HP Date: 27/04/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 3:42:12 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 32027

Part Number: D33872

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 07/04/24

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ML 07/04/24

3

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: UA25

KE 07-04:25 3

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

07/04/26

Job Completion



U 07-04-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	32021
Description: Arm		Part Number:	D3387-2
Inspection Dwg: D3387 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	.502	✓			
7.577	+/-0.010	5.580	✓			
R0.030	+/-0.010	.030	✓			
Ø0.191	+0.005/-0.000	.193	✓			
1.700	+/-0.010	1.701	✓			
0.188	+/-0.010	.188	✓			
11.405	+/-0.010	11.406	✓			
Ø0.507	+0.000/-0.001	.507	✓			
2.033	+/-0.005	2.033	✓			
R0.300	+/-0.010	.300	✓			
1.000	+/-0.005	1.000	✓			
2.000	+/-0.010	2.001	✓			
1.347	+/-0.005	1.348	✓			
0.250	+/-0.010	.254	✓			
R0.125	+/-0.010	.125	✓			
0.125	+/-0.010	.130	✓			
R0.032	+/-0.010	.032	✓			
Ø0.375 x100°	+/-0.010	373X100°	✓			
0.500	+/-0.010	.501	✓			
0.300	+/-0.010	.298	✓			

Measured by:	JL	Audited by:	aml	Prototype Approval:	N/A
Date:	07/04/24	Date:	07/04/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue	KJ/JLM	<i>[Signature]</i>

DART

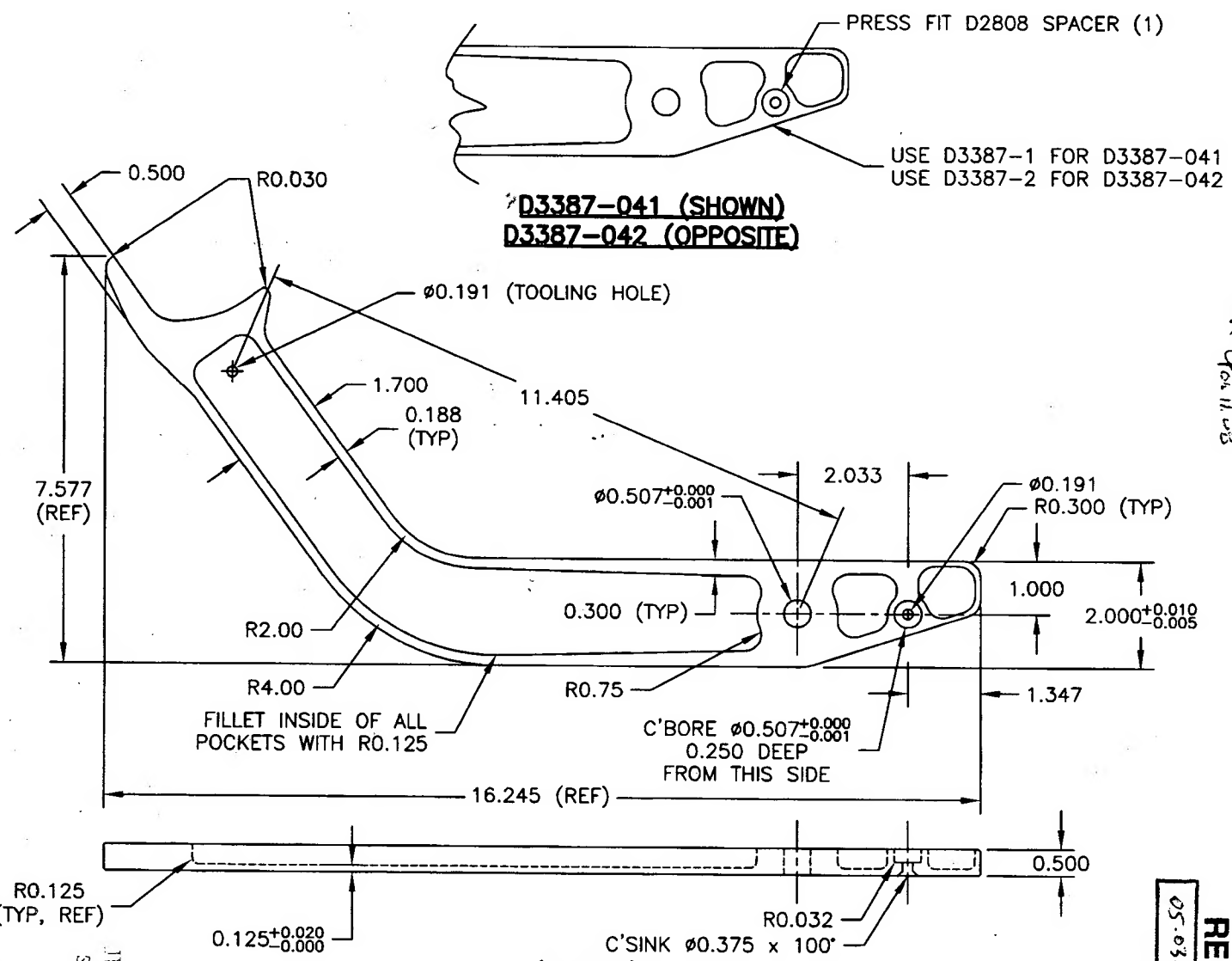
DESIGN REVIEW

Arm height to change

OK Per 11.018

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAMKESBURY, ONTARIO, CANADA
DATE 05.01.18	DRAWING NO. D3387	REV. A
	TITLE ARM	SHEET 1 OF 1
A	05.01.18	SCALE 1:3
	NEW ISSUE	

RELEASED
05.03.11



D3387-041 (SHOWN)
D3387-042 (OPPOSITE)

D3387-1 (SHOWN)
D3387-2 (OPPOSITE)

GENERAL NOTES

- MACHINE PER DRAWING FILE "D3387-A.DWG"
- MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11) 0.500 THICK (REF DART SPEC. M6061T6B0.500)
- DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32027